User:

Tuesday, 21/10/2008 2:46:01 PM

Julie Dawson

Process Sheet

Customer

Prsht Rev.

First Issue

Previous Run

: CU-DAR001 Dart Helicopters Services

: 42777

Job Number **Estimate Number** : 10329

P.O. Number

This Issue

: 21/10/2008

: NC

: //

: 41128

: MACHINED PARTS Type

Part Number

Drawing Name

Drawing Number

: D2743 : D2743 REV B

: N/A Project Number

: B **Drawing Revision**

Material **Due Date**

: 15/11/2008

: CROSSBOLT SPACER

Each

Written By Checked & Approved By

Comment

S.O. No. :

Reformat; removed tumble and deburr step KJ/J : Est E 05.04.13

LM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M6061T6T0625W065

6061-T6 RD Tube .625 x.065W



Comment: Qty.:

0.2800 f(s)/Unit

Total:

56.0070 f(s)

Material: 6061-T6 (WW-T-700/6)

Ø0.625 " x 0.065" wall

(M6061T6T0.625W.065)

Batch: m lo201

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: 1-TURN AS PER FOLIO FA202 & DWG D2743

FOLIO REV:

2-DEBURR AS REQUIRED

3.0

QC2



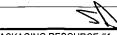
Comment: INSPECT PARTS AS THEY COME OFF MACHINE 4.0

QC8

SECOND CHECK



Comment: SECOND CHECK







5.0

PACKAGING

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: //A/L





W/O:	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		.*	,					t.
Part No):	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	Date: _	
				QA:	N/C Close	ed:	Date: _	
NCR: WORK OF			WORK ORDER NON-CONFO	RDER NON-CONFORMANCE (NCR)				

		WORK ORD	ER NON-CONFORMAN	CONFORMANCE (NCR)				
T	Description of NC		Corrective Action Section B			Ammanal	A	
STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
		·						
	STEP	STED Description of NC	STEP Description of NC Section A Initial	STEP Description of NC Section A Initial Action Description	STEP Description of NC Section A Initial Action Description Sign &	STEP Section A Initial Action Description Sign & Section C	STEP Description of NC Section A Initial Action Description Sign & Verification Section C Chief Eng	

NOTE: Date & initial all entries

Date: User: Tuesday, 21/10/2008 2:46:01 PM

Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 42777

Part Number: D2743

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE

14

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08 10.29

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				· \			

Part No:	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	losed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NC							
		Description of NC	Corrective Action Section B			Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector	
	•								
ı									

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	42727
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

		X First A	rticle [Prot	otype	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.085	+0.030/-0.000	3.095	J,			
Ø0.625	+/-0.010	\$.63				
0.050 x 45°	+/-0.010 x 45°	050×41			_	
0.065	+/-0.010	600				
		'				
						·
						·
	·				T	i

Measured by:	Lann	Audited by:	Prototype Approval:	N/A
Date:	26/2/25	Date: 5/10/26	Date:	N/A

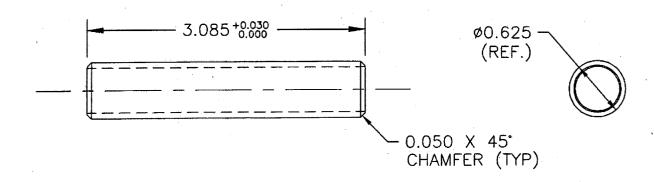
Rev	Date	Change	Revised by	Approved
Α	04.04.20	New Issue	KJ/RF	1
В	06.11.20	Tolerance +/-0.010 x 45° was 0.48 x 45°	KJ/JLM	





DESIGN		DRAWN BY	DART AEROSPACE BELLEVUE, WA	USA, INC.
CHECK	A	APPROVED	DRAWING NO. D2743	REV. B SHEET 1 OF 1
DATE		1 / _	TITLE	SCALE
98.1	2.08		CROSS BOLT SPACER	1:1
 Α	·	98.04.16	NEW ISSUE	
В	·	98.12.08	3.085 WAS 3.060	





MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY RETURN TO

ENGINEERING UNCONTROLLED CORY

SUBJECT TO AMENDMEN

WITHOUT NOTICE